

Date: Thursday, 05/06/2008 8:30:49 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: 350 SKIDTUBE EXTRUSION (BENT)		
Job Number	: 39714			Part Number	: D26003BENT		
Estimate Number	: 10997			Drawing Number	: D2600 D1/D2750 E		
P.O. Number	:			Project Number	: N/A		
This Issue	: 05/06/2008	S.O. No.	:	Drawing Revision	: D1/E		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: MACHINED PARTS	Due Date	: 12/06/2008	Qty:	20
Previous Run	: 38463			Um:	Each		
Written By	:			Comment	: Est. B02.11.28 Reformat KJ		
Checked & Approved By	:						
Comment	:						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D26003120	Extrusion Round 3" 350	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Extrusion Bent Pick: Qty Part Number Description Batch 1 D2600-3 Extrusion <i>57756</i>			
2.0	BENDING	BENDING MACHINE - SKIDTUBES	
Comment: BENDING MACHINE Deburr one end of extrusion Drill #30 pilot holes using DT8689 Open holes to 5/16" and deburr Bend using CNC bending machine as per program 2750.C and Folio FT003. Use 5/16 locator pin on buggy "A". Check fit to Jig DT8150			
3.0	QC5	INSPECT WORK TO CURRENT STEP	
Comment: INSPECT WORK TO CURRENT STEP Inspect work to Step 6 Ensure fit to Jig DT8150			
4.0	PACKAGING 1	PACKAGING RESOURCE #1	
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>skid tube cell</i>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 350 SKIDTUBE EXTRUSION (BENT)

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Part Number: D26003BENT

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC21

FINAL INSPECTION/W/O RELEASE



08/06/12 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-06-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>DKY</i>	DRAWN BY <i>DKY</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>AS</i>	DRAWING NO. D2600	REV. D SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASER
18 08 25 DS

A	97.01.21	NEW ISSUE
B	97.09.09	CHANGE MATERIAL SPEC.
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.
D	98.08.20	INCREASE MIN. UTS TO 40 KSI
D1	01.04.17	ADD PART NUMBERS & DIE NUMBERS <i>+ GP</i>

GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED
TO ASTM STANDARD B221 BY AN APPROVED TESTING
FACILITY TO ENSURE THAT THE BATCH MEETS THE
ABOVE MINIMUM MECHANICAL PROPERTIES.

2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE
NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

W039714

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

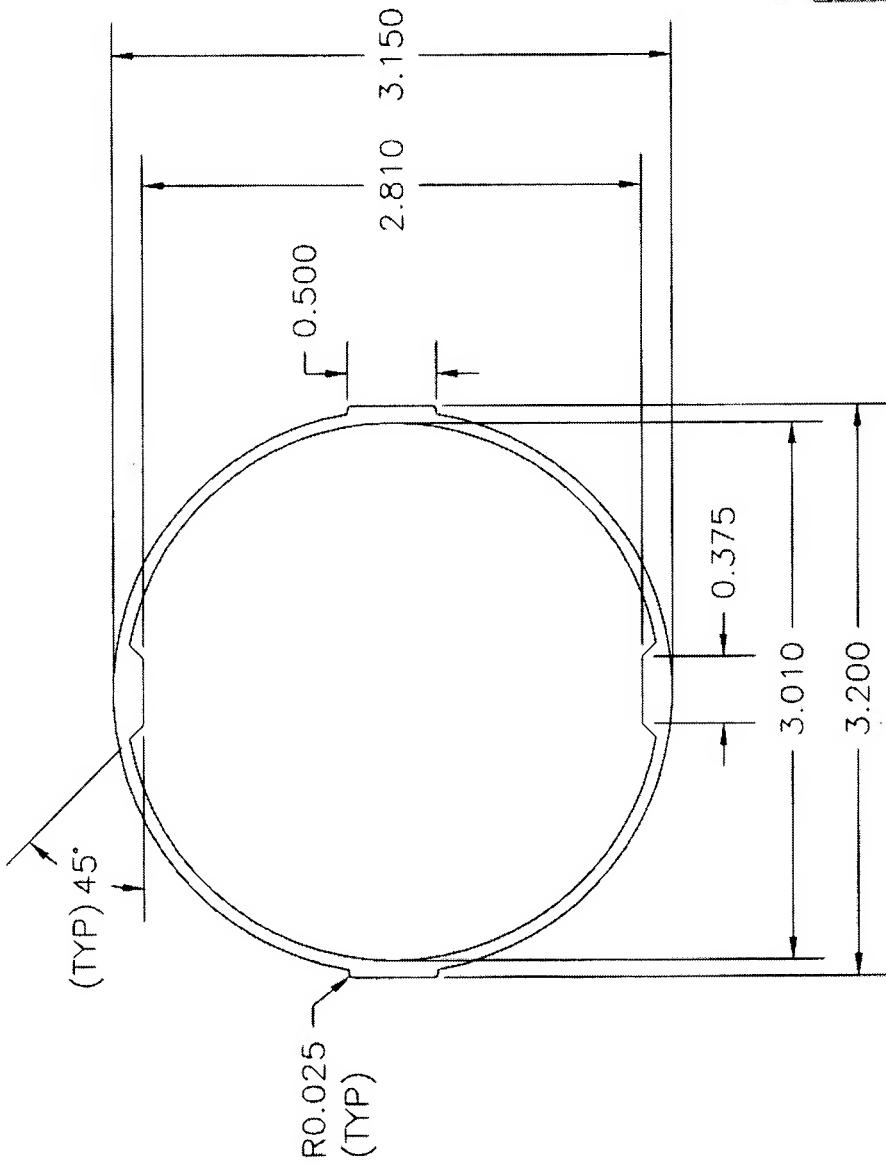
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>DR</i>	DRAWN BY <i>ME</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>JL</i>	DRAWING NO. D2600	REV. D SHEET 2 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98.8.25 DS



D2600-1

MANUFACTURED WITH CARADON INDALEX DIE # MH-18870
or, FOR L DIE # 897121 (PREFERRED CHOICE)
PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-100 IS 100" LONG)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

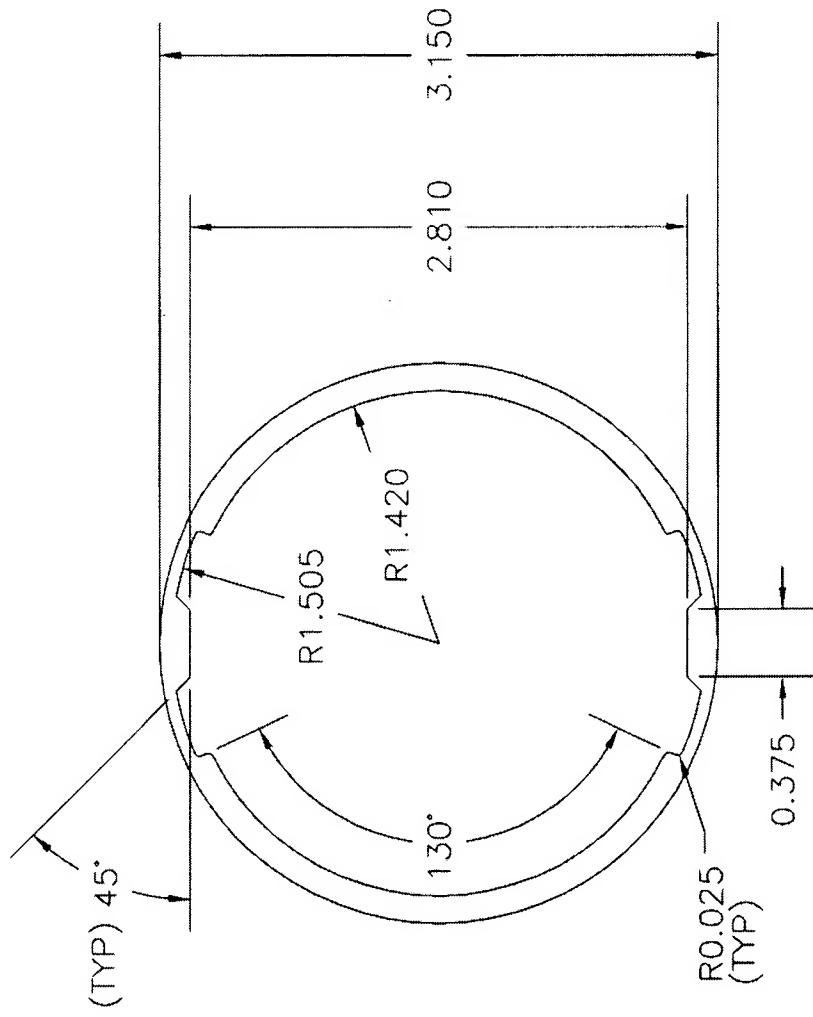
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



COPIES
OK

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D
RE	JF	D2600	SHEET 3 OF 5
DATE		TITLE	SCALE
98.08.20		EXTRUSION	1:1



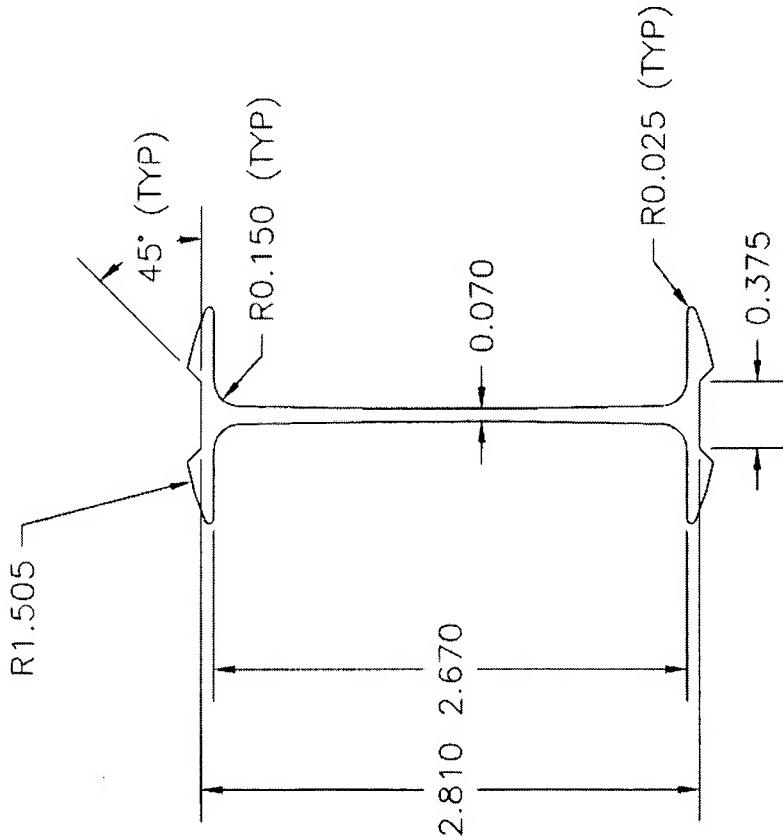
D2600-3

MANUFACTURED WITH CARADON INDALEX DIE # MH-18859
OR BON L DIE # 897122 (PREFERRED CHOICE)
PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (E.G. D2600-3-120 IS 120 long)



DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D
KE		D2600	SHEET 4 OF 5
DATE		TITLE	SCALE
98.08.20		EXTRUSION	1:1

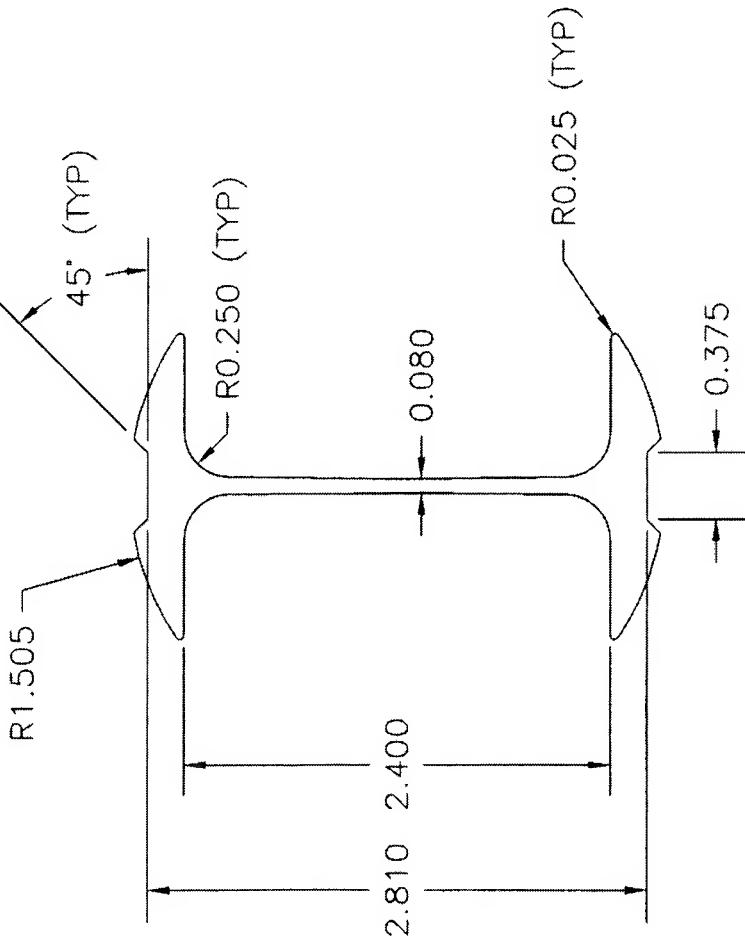
RELEASED
98.8.25 DSD2600-5

MANUFACTURED WITH CARADON INDALEX DIE # MS-18871
PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES
(E.G. D2600-5-108 IS 108" LONG)



DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D
KE	AS	D2600	SHEET 5 OF 5
DATE		TITLE	SCALE
98.08.20		EXTRUSION	1:1

RELEASED
16.8.25 DSD2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-7-125 IS 125" Long)

